

Work Order ID 78900

78900

Page 1

January-17-12 11:51:50 AM

Item ID: D2744 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cap
 Start Date: 17/01/2012 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2744	Rev C

100	FLOW WATER JET	0.00							
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100
 Waterjet
 FLOW CNC Waterjet
 5057 0810
 Memo
 1-Cut as per Dwg D2744
 Dwg Rev: C
 Prog Rev: C
 2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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110
 QC
 Quality Control
 Memo

120	QC8- Inspect parts - second check	0.00							
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120
 QC
 Quality Control
 Memo

B12-2-14

(42)

B12-2-14

5/12/15

cont
 (42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>LC</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging	***STOCK IN SKIDTUBE CELL***								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/2/12 (42)

MLJ 12/02/17

12/02/14 (42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

January-17-12 11:51:53 AM

Page 1

Work Order ID: 78900

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Parent Item: D2744

D2744

Parent Item Name: Cap

Start Date: 17/01/2012

Required Date: 31/01/2012

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP C03.01.17Reformat; Dwg revisedKJ/RF
IPP Rev:D Now on Waterjet 06-06-16 JLM
IPP Rev:E As per Rev C 07-07-28 JLM Verified By:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M5052H32S.080

Purchased

No

100

sf

41.0000

0.1823

5.756842

8.

M5052H32S 080

**

B12-2-14

5052-H32 .080 Sheet

Location

Loc Qty

Loc Code

MAT022

41

100742

35

100974

4

19729

2

100742

42

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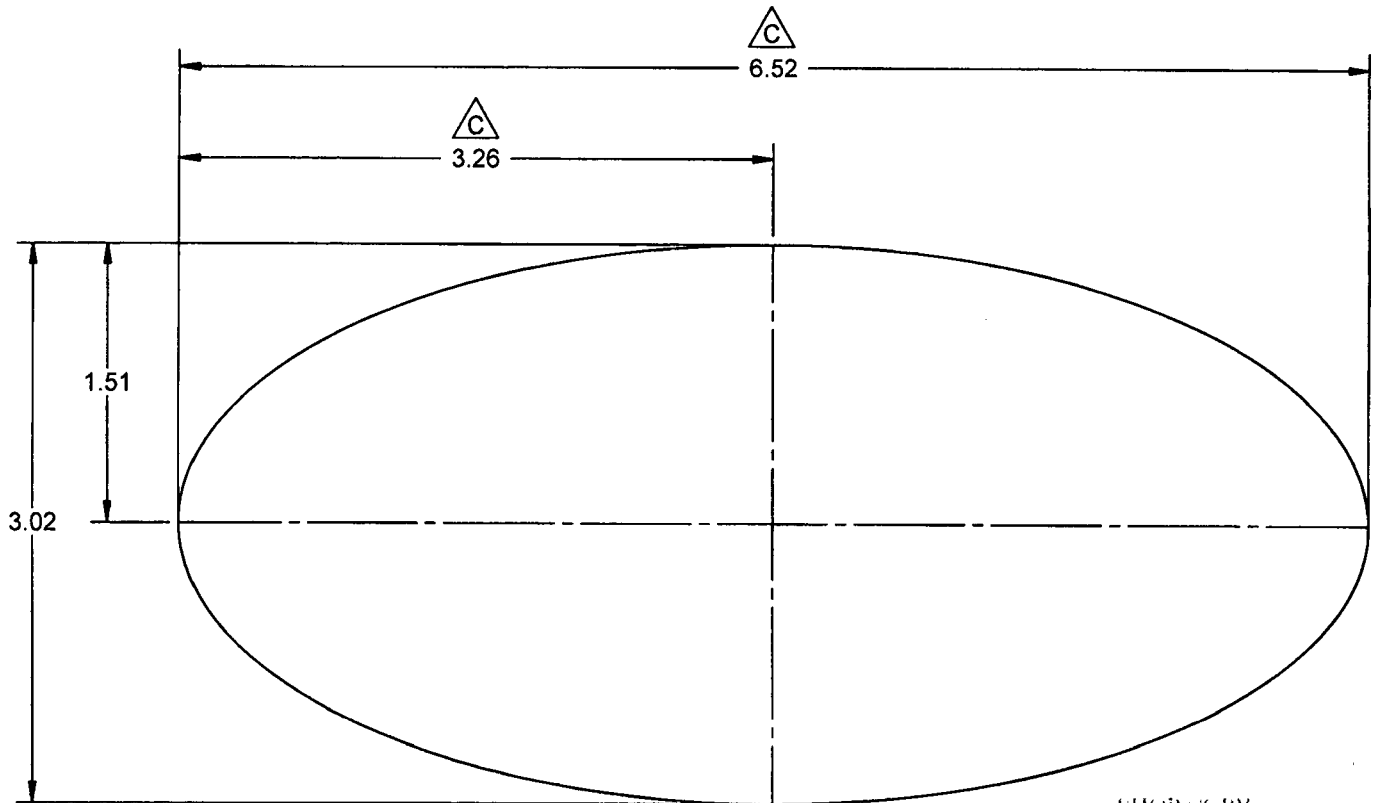
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DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED JH	APPROVED #	DRAWING NO. D2744	REV. C SHEET 1 OF 1
DATE 06.10.05		TITLE CAP SCALE 1:1	
REV	DATE	DESCRIPTION	
A	98.04.16	NEW ISSUE	
B	02.12.18	RE-DESIGN	
C	06.10.05	3.26 WAS 3.13; 6.52 WAS 6.27	

RELEASED
07-08.02-#



D2744 CAP

SHOP COPY
REFUSED
ENGINEER
UNCONTROLLED COPY
SUBJECT TO CHANGE
WILL BE USED
WORK IN PROGRESS

NO. 78900 M.L.J.
12/01/17

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6 SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.080)
OR ALUMINUM 5052-H32 SHEET 0.080 THICK PER QQ-A-250/8 OR AMS 4016
(REF DART SPEC M5052H32S.080)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS

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